

Work Order ID 57976

April 21, 2010 9:56:56 AM



Page 1

Item ID: D4038-11

Revision ID:

Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00

Required Date: 30/04/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

B

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.750" LONG

0.00

0.00

ent 10/04/24

#7 0

105



HAAS I

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA886

DWG REV: *B*

FOLIO REV: *AA*

DEBURR

0.00

0.00

ent 10/04/26

7 0

Pto
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4038-11 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 10.05.03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>57976</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.04.26	105	(STY) the $\phi 0.189"$ HOLE IS $0.197"$ RL Process. Drill ^{Drill} welded	<u>CP</u> 10.04.26 pi- 051 072	Bolt Acceptable. Bolt holds spacer in place. Not high stress hole.	<u>SMH</u> 10/04/26	<u>S</u> 10/04/26	<u>CP</u> 10.04.26 pi- 051 072	<u>S</u> 10/04/26

NOTE: Date & initial all entries

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Item ID: D4038-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Block

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

anh 10/04/26

7

Ø

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MF 10/04/26

7

Ø

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Jul 10/04/27

x7

Ø

Hand Finishing

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑦ BR 10-4-27

160

Identify as per dwg & Stock Location: 110

0.00



Packaging

Memo

0.00

Packaging

PC 10/4/27 ⑦

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/28 ⑦
BR 10-4-27
⑦

Picklist Print

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Page 1

Work Order ID: 57976

Parent Item: D4038-11

Parent Item Name: Block

Comments: lpp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	9.5000	0.6989			



6061-T6 Bar 1.50 x 2.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT10

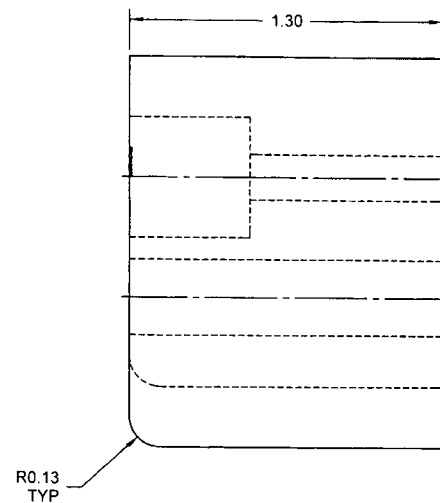
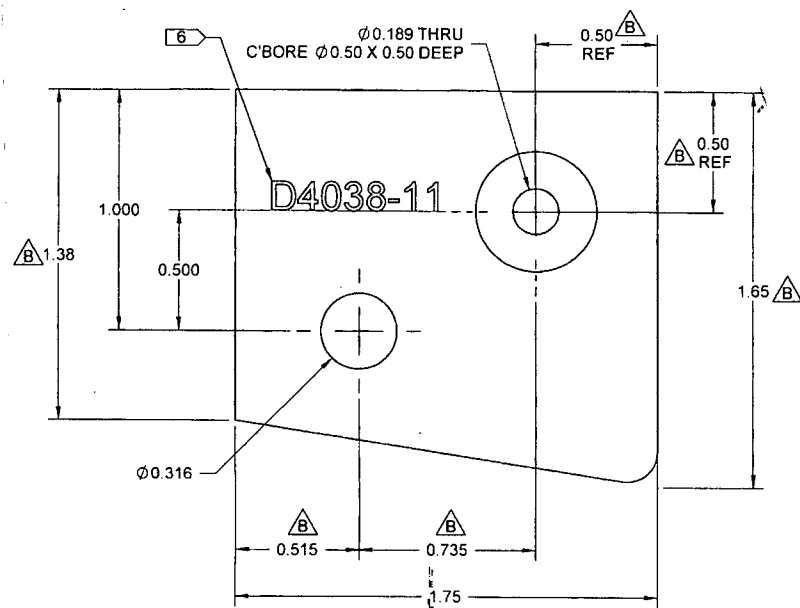
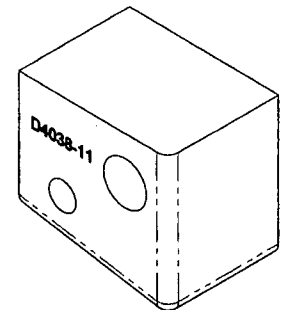
110167

9.5

9.5

.6989 *mk* 10/04/24

W/057976



D4038-11 BLOCK

RELEASED
2010-04-16

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4038	SHEET 13 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	